

Date: Thursday, 6/15/2006 1:41:46 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 27561
 Estimate Number : 11036
 P.O. Number : N/A Part Number : D2804041
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2804 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : B
 Previous Run : 27102 Material : N/A
 Due Date : 7/2/2006 Qty: 16 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *06.06.15*
 Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28041 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

STA 155 Bracket

Pick:

Qty Part Number Description Batch

1 D2804-1 Bracket *B 27615*

2.0 D28051 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Stop

Pick:

Qty Part Number Description Batch

1 D2805-1 Stop *B27113 (6) B27616 (10)*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-1 into arm as per Dwg D2804

SAD 06.07.05 16

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/07/06 16

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL SC 06/07/06 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27561

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/07/11 18

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Press D2809 into arm as per Dwg D2804

SB 06/07/12 16

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C16A

Bolt

M101189

9.0

D2809

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

1

D2809

Bushing

B 27617 ⑤
B 27306 x 7mm

B 22529 7mm

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 32.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

2

MS21043-3

Nut

M100218

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4 NAS1515H3

Washer

A/R

LPS-3

Corrosion Spray

M19633
M12395

SB 06/07/11 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27561

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SB 06/07/11 (18)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.07.12 16

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 157 ST 158

06/17/13 (16)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.14

Job Completion



11 06.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

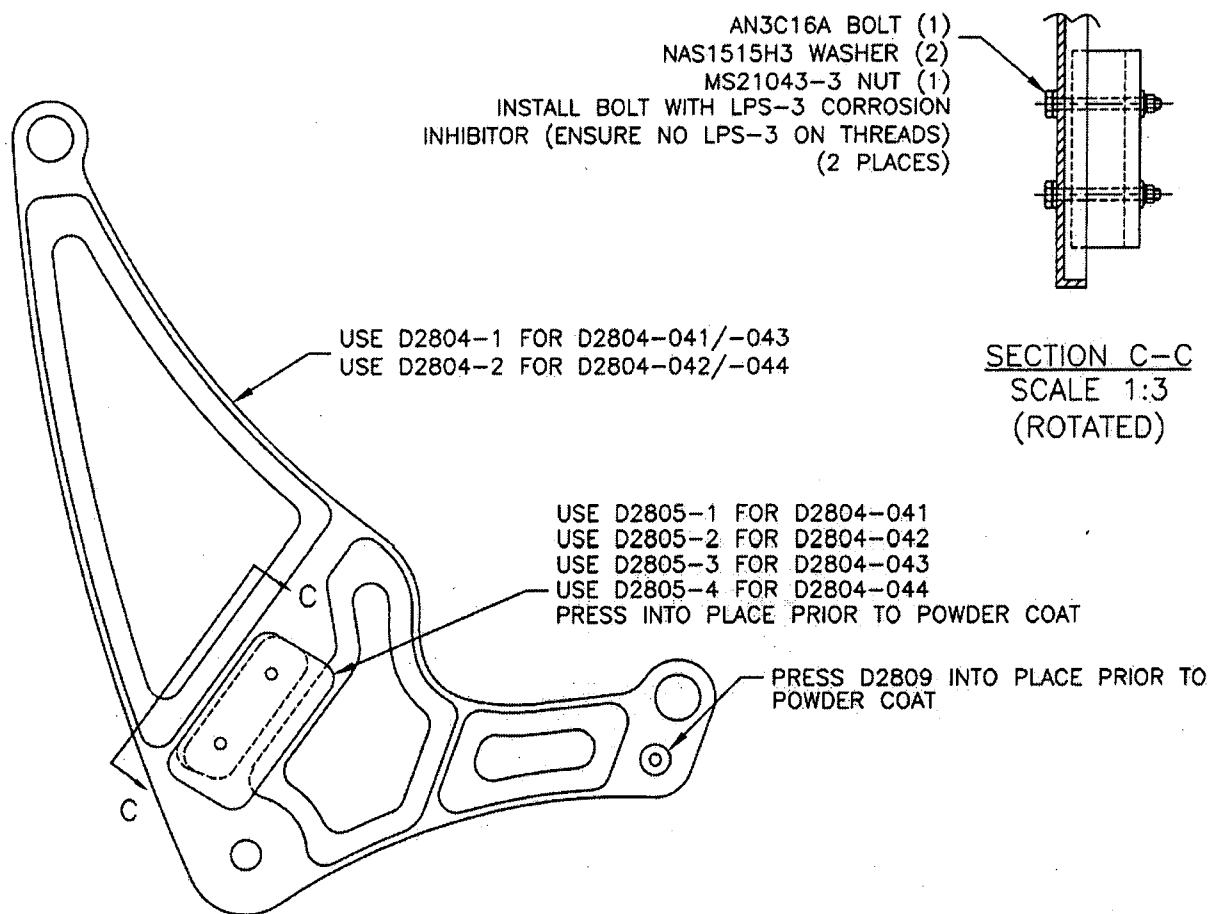
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D2804	SHEET 2 OF 2
DATE	TITLE	SCALE	
04.11.22	STA 155 BRACKET	1:3	



RELEASED

05-03-11 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QST 005 4.3

WORK ORDER
NO. 27561

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